

Sip 24/10

SP/ST

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CABIN FLOOR PROTECTOR		
Job Number	: 35240-1					
Estimate Number	: 12660					
P.O. Number	: N/A			Part Number	: D35741	
This Issue	: 18/10/2007 S.O. No. : N/A			Drawing Number	: D3574 REV.A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A	
Previous Run	: 33356			Material	: N/A	
Written By	:			Due Date	: 24/10/2007	
Checked & Approved By	:			Qty:	4 Um: Each	
Comment	: Est Rev A New Issue 07-01-22 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	F60029	lexan grey	
		Comment: Qty.: 32.0000 sf(s)/Unit Total: 128.0000 sf(s) F60029 lexan sheet Batch: 105330 1B 07-10-19	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev: A 1B 07-10-19 Prog Rev: A	(4)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1B 07-10-19	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK 6 09/10/19 (41)	counts
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.	5AD 07/10/20 (4)

Date: Thursday, 18/10/2007 1:22:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 35240

Part Number: D35741

Job Number:

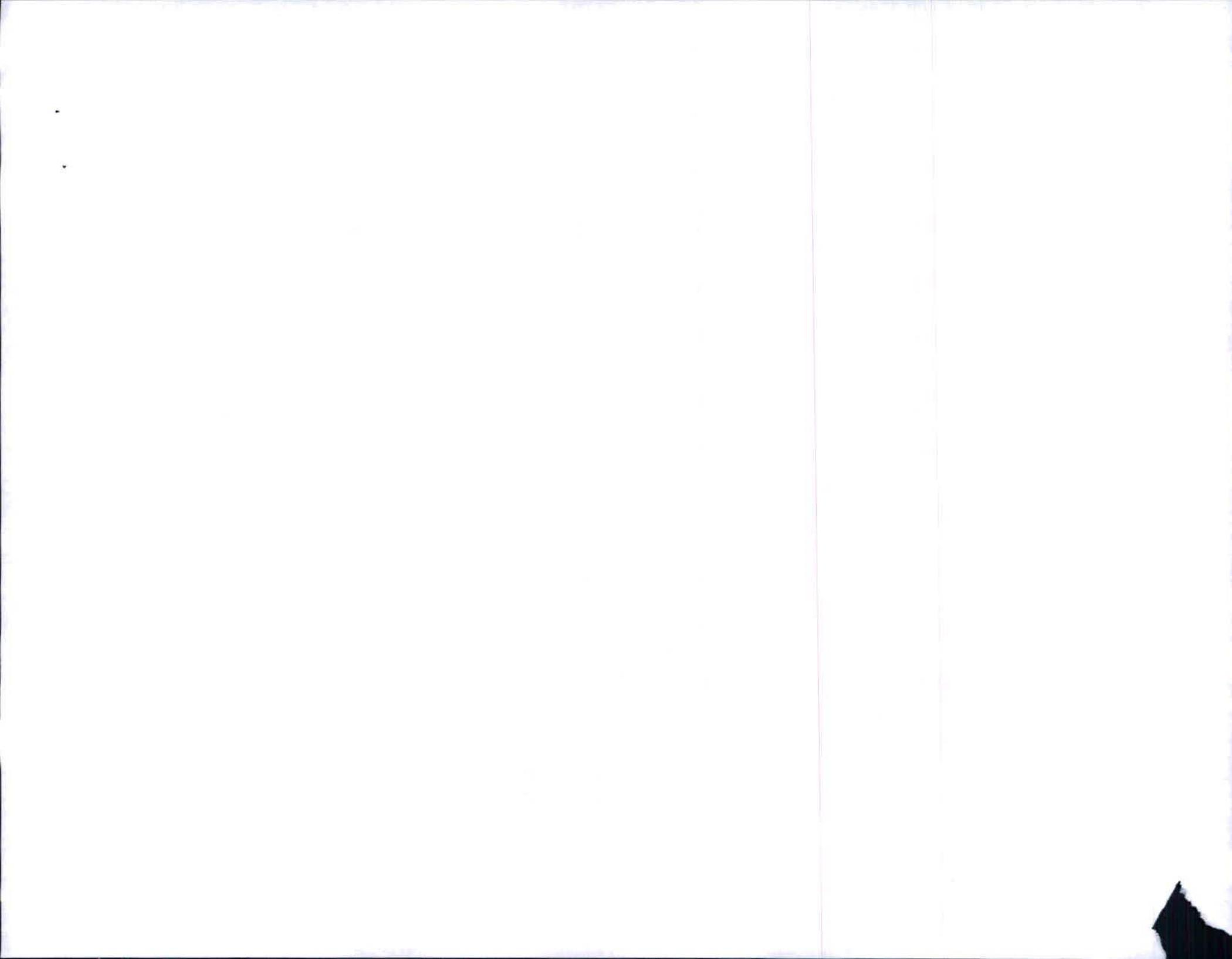


Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>207/10/22 (2)</i>
Comment:	INSPECT WORK TO CURRENT STEP	
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>207/10/20 (2)</i>
Comment:	PACKAGING RESOURCE #1	
	Identify with P/N and B/N using a permanent fine point marker, then Stock	
	Location:	<i>207/10/22 (2)</i>
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>207/10/25 (2)</i>
Comment:	FINAL INSPECTION/W/O RELEASE	

Job Completion



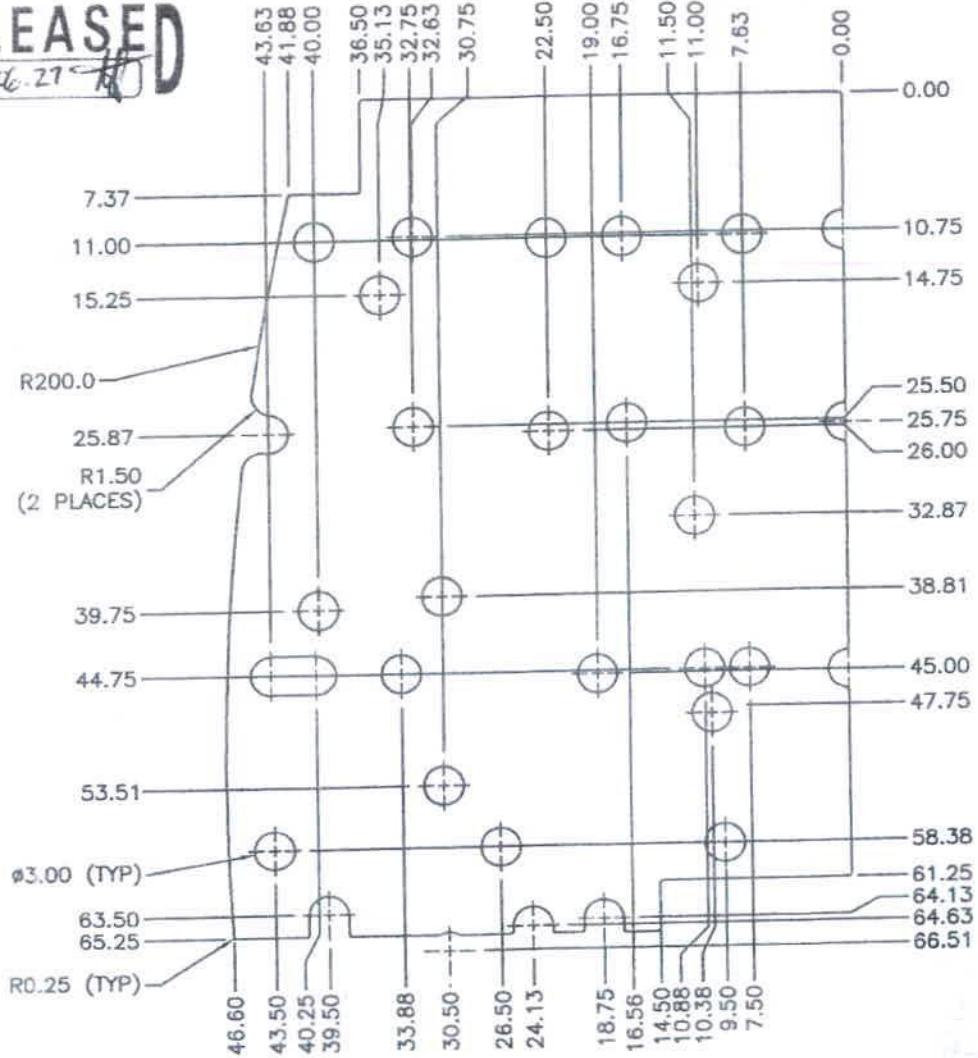
207/10/25



DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07.06.27



D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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DART AEROSPACE LTD

Work Order:

35240

Description: CABIN FLOOR PROTECTOR

Part Number:

D3574-1

Inspection Dwg: D3574-1 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Φ3.00	+.012 -.001	2.999 *				
7.37	+/- .030	7.37 *				
11.00	+/- .030	11.00 ±				
15.25	+/- .030	15.25 *				
25.87	+/- .030	25.87				
39.75	+/- .030	39.75				
44.75	+/- .030	44.75				
53.51	+/- .030	53.51				
63.50	+/- .030	63.50				
65.25	+/- .030	65.25				
10.75	+/- .030	10.75				
14.75	+/- .030	14.75				
25.50	+/- .030	25.50				
25.75	+/- .030	25.75				
26.00	+/- .030	26.00				
32.87	+/- .030	32.87				
38.81	+/- .030	38.81				
45.00	+/- .030	45.00				
47.75	+/- .030					
58.38	+/- .020	58.38				
61.25	+/- .030	61.25				
64.13	+/- .030	64.13				
64.63	+/- .030	64.63				

Measured by: HB

Audited by: En

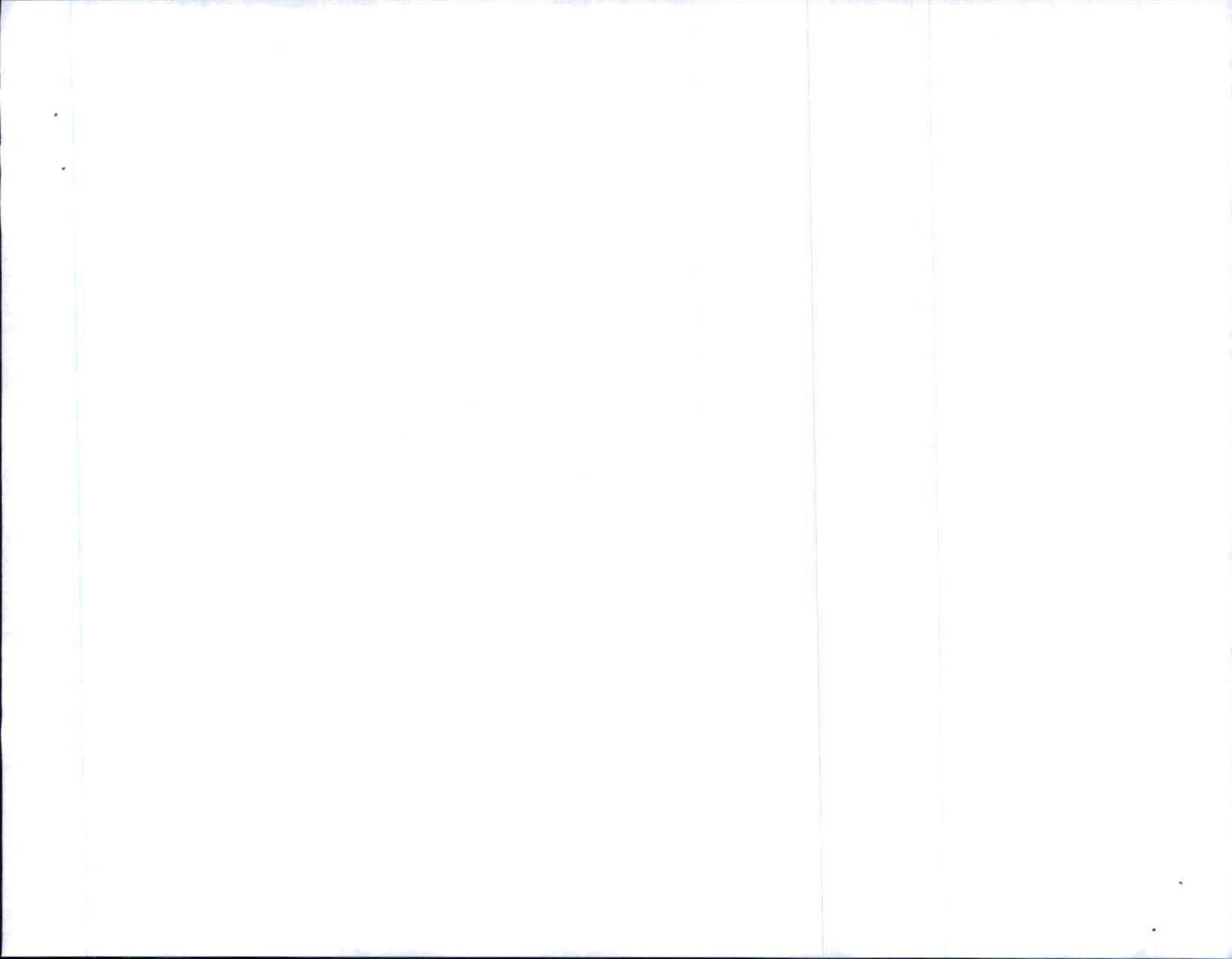
Prototype Approval: / /

Date: 07-10-14

Date: 07/10/14

Date: / /

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	/



CART AEROSPACE LTD	Work Order:	35340
Description: CABIN FLOOR PROTECTOR	Part Number:	D35-4-1
Inspection Doc: D3574-1 Rev: A		Page 1 of 1

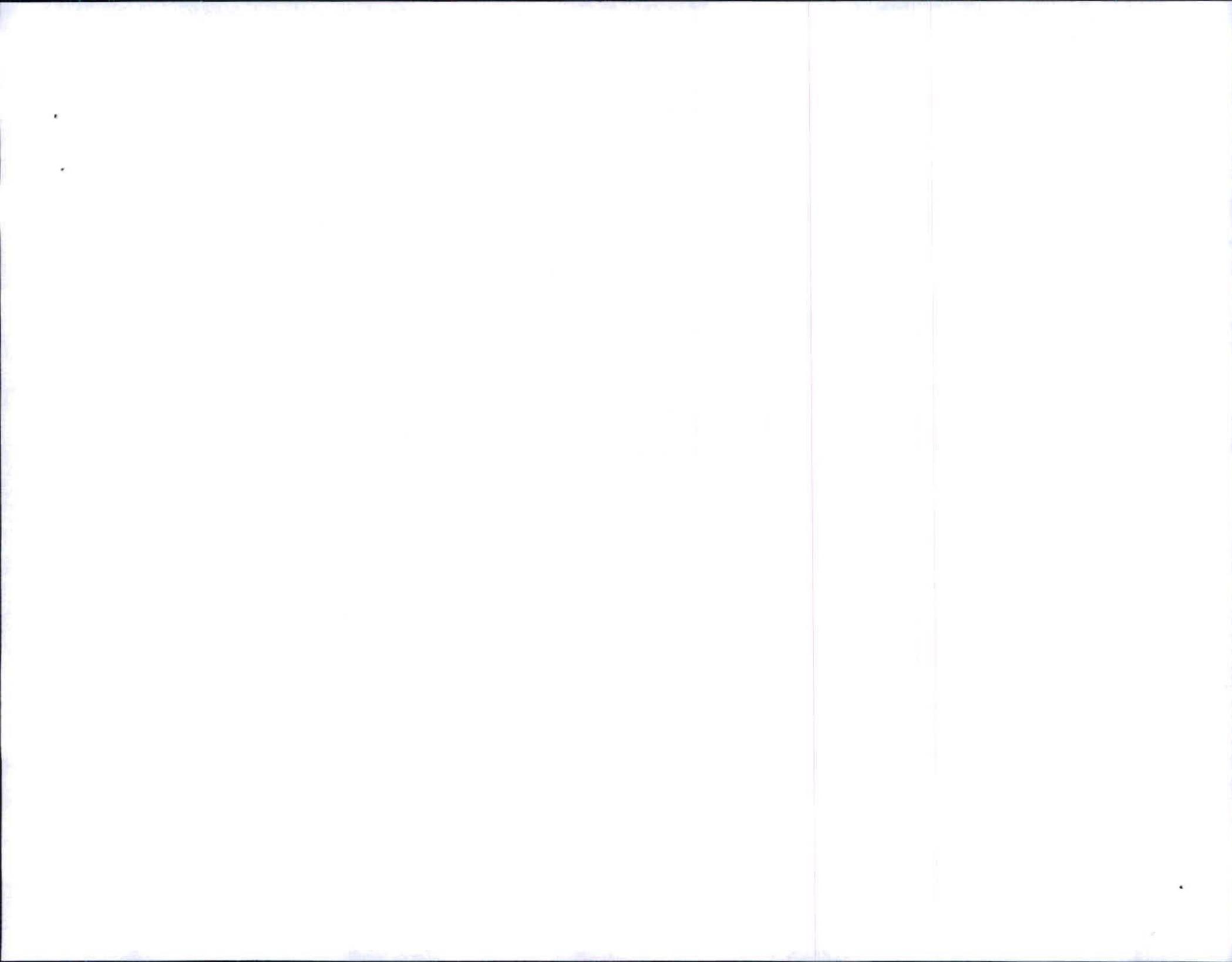
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
46.60	+/- .030	46.60				
43.50	+/- .030	43.50				
40.35	+/- .030	40.35				
39.50	+/- .030	39.50				
33.88	+/- .030	33.88				
30.50	+/- .030	30.50				
26.50	+/- .030	26.50				
24.13	+/- .030	24.13				
18.75	+/- .030	18.75				
16.56	+/- .030	16.56				
14.50	+/- .030	14.50				
10.88	+/- .030	10.88				
10.38	+/- .030	10.38				
9.50	+/- .030	9.50				
7.50	+/- .030	7.50				

Measured by: HB	Audited by: S	Prototype Approval: <input checked="" type="checkbox"/>
Date: 07-10-19	Date: 07-10-19	Date: <input checked="" type="checkbox"/>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



CART AEROSPACE LTD	Work Order:	35240
Description: CABIN FLOOR PROTECTOR	Part Number:	D3574-1
Inspection Dwg: D3574-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.63	+/- .030	43.63	X			
41.88	+/- .030	41.88	X			
40.00	+/- .030	40.00	X			
36.50	+/- .030	36.50	X			
35.13	+/- .030	35.13	X			
32.75	+/- .030	32.75	X			
32.63	+/- .030	32.63	X			
30.75	+/- .030	30.75	X			
22.50	+/- .030	22.50	X			
19.00	+/- .030	19.00	X			
16.75	+/- .030	16.75	X			
11.50	+/- .030	11.50	X			
11.00	+/- .030	11.00	X			
7.63	+/- .030	7.63				

Measured by: HB	Audited by:	Prototype Approval:
Date: 07-10-19	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

